Work Order ID 86828

July-06-12 3:01:40 PM

86828

Item ID: D3393-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Battery Lock Assembly

Start Date: 7/06/12 **Start Qty:** 4.00 *4*

Required Date: 7/06/12 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** M **Date:** 12-07-9 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3393	Rev A								
100		0.00							FF
100	Small Fab					4	0		13-01-16
Small Fab	**Memo**	0.00							
Small Fab	1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.2-Using the flat cam, fabricate D3369-5 as per Dwg D3369Identify as D3369-53-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten								
110		0.00							
110	Large Fab					(4)	EZ	13-1-15	
Large Fab	**Memo**	0.00							
Large Fab	Tack Weld lock shaft to flat cam of a Max 1/8" Long QtyPart Number Description Batch A/RN/A SS Rod M122357								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120						(4)			
QC	**Memo**	0.00							
Quality Control									

QC 13-1-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D3393-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Battery Lock Assembly
Start Date: 7/06/12 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 7/06/12 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							FF
130	Small Fab					4	0		13-01-17
Small Fab	**Memo**	0.00							
Small Fab	Apply Crazy Glue to cap and press into Body 9567K21 Batch: 123 666								
140	QC5- Inspect part completeness to step on W/O	0.00 SM				4			
140									
QC	**Memo**	0.00 13-1-17							
Quality Control									
150	Identify as per dwg & Stock Location:_____	0.00				4X			SD
150									13-01-18.
Packaging	**Memo**	0.00							
Packaging									

PPP 95557 1X.
BPP 955963X.

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 86828

July-06-12 3:01:40 PM

86828

Item ID: D3393-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Battery Lock Assembly

Start Date: 7/06/12 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 7/06/12 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

13/01/22

pl 13-01-21

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July-06-12 3:01:40 PM

Work Order ID: 86828
Parent Item: D3393-041
Parent Item Name: Battery Lock Assembly

Start Date: 7/06/12 **Required Date:** 7/06/12
Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC SS Flat Washer 5/16 FW516S1		Purchased	No			100	Each	1,694.0000	2	8	FF	13-01-16	
				Location		**Loc Qty**		**Loc Code**					
				ST377		1674							
					120262	1674				8			
				ST522		20							
					120208	20							
9567K21 Polyetheline Cap		Purchased	No			100	Each	91.0000	2	8	FF	13-01-16	
				Location		**Loc Qty**		**Loc Code**					
				ST380		91							
					120743	91				8			
D3373-1 Cam Lock		Manufactured	No			100	Each	39.0000	1	4	FF	13-01-16	
				Location		**Loc Qty**		**Loc Code**					
				ST039		39							
					58463	1							
					~~74862~~	19				4			
					75666	19							
D3393-1 Battery Lock Casing		Manufactured	No			100	Each	11.0000	1	4	FF	13-01-16	
				Location		**Loc Qty**		**Loc Code**					
				st493		11							
					79171	11				4			
D3393-3 Cam Lock Shaft		Manufactured	No	84320		140	Each	0.0000	1	4	FF	13-01-16	
										4			

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

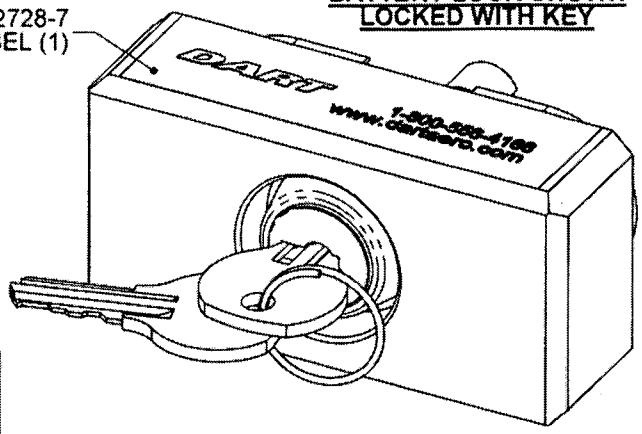
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

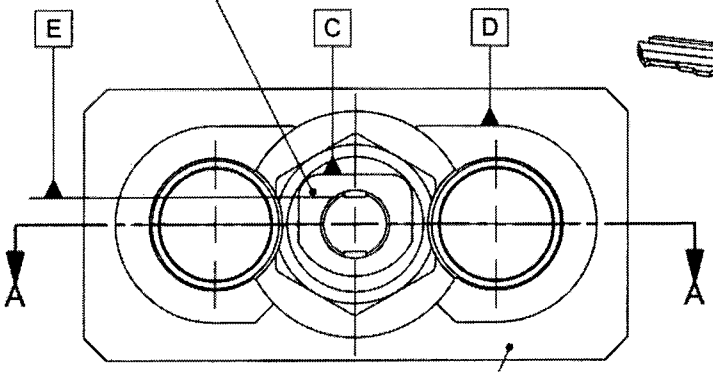
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

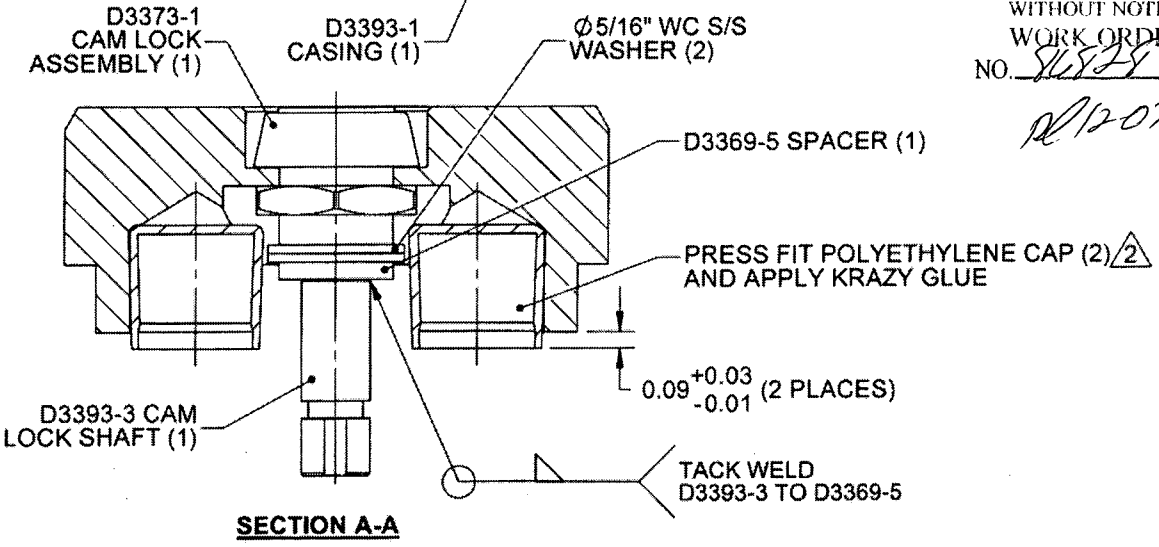
RELEASED
05/02/09

BATTERY LOCK SHOWN LOCKED WITH KEY





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 96829
12079



SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

1) WELD PER DART QSI 004
2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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W/O:		WORK ORDER CHANGES					
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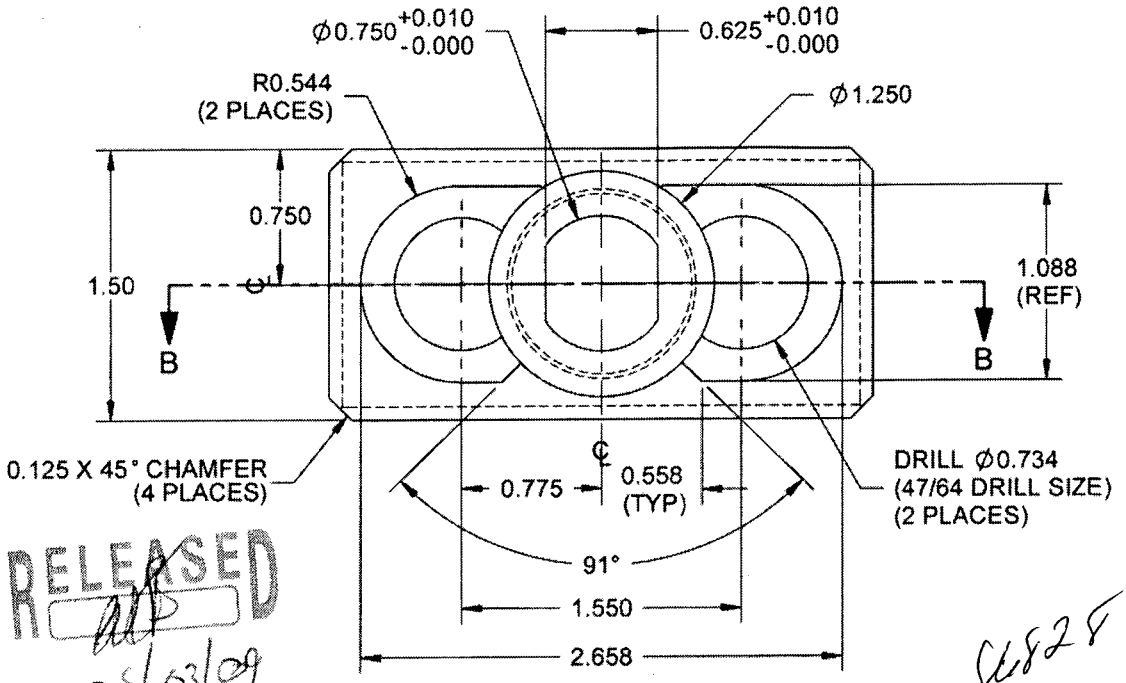
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

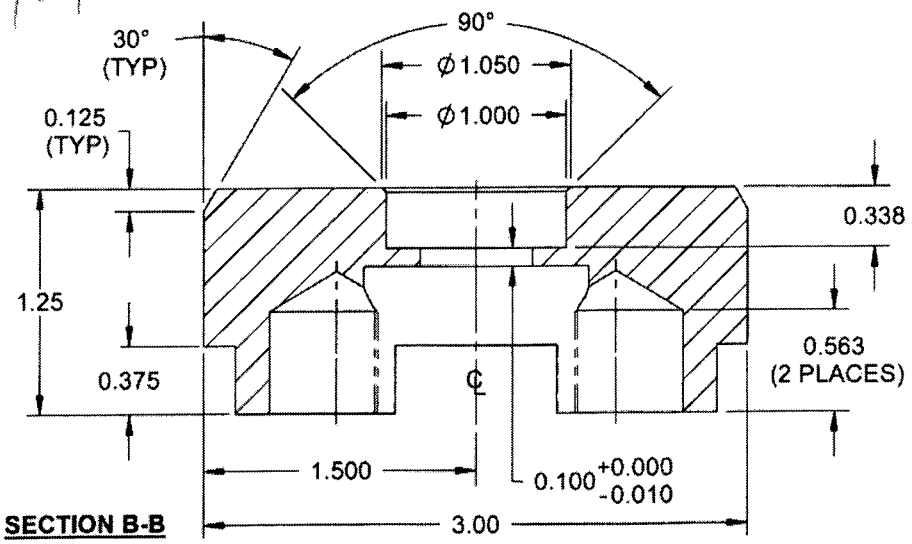
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



RELEASED
05/03/09



SECTION B-B

D3393-1 CASING

NOTES:

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

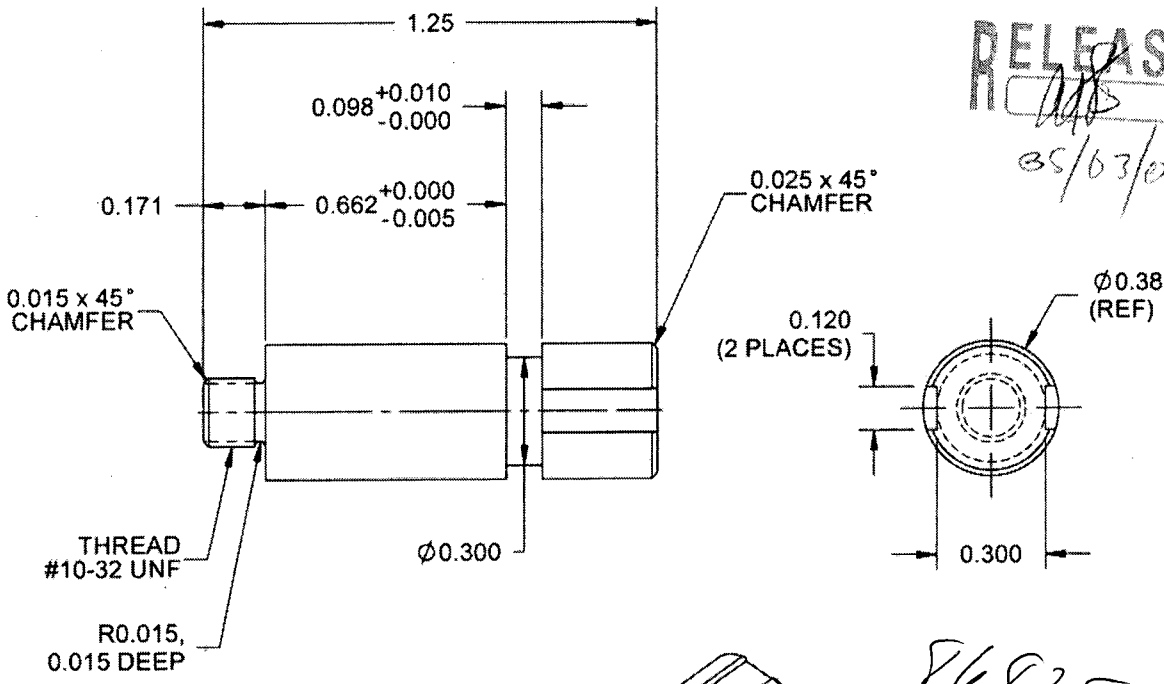
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

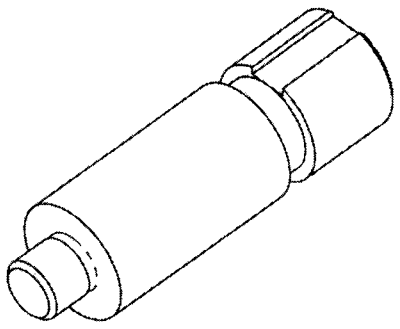
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

* **NOTE:** Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1

RELEASED
05/03/09





D3393-3 CAM LOCK SHAFT

NOTES:

1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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